



Dart Aerospace Ltd.
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Canada

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D2661-2**Job Sheet 186286****Part No:** D2661-2**Job Qty:** 4 pcs**Part Name:** Saddle, RH, Fwd, Aft, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/13/18**Job Tracking No:****Due Date:** 11/19/18**Created By:** Jesse White**Type:** SOLD**Description:**

Note: DWG REV E IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP REV:D REDESIGN
PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	11/19/18		0.00	6.56	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 18/11/16
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	11/19/18		0.00	0.26	Conventional Mill - 1 - B4B		SBL 18/11/16
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	11/19/18		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 16		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		

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				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	36L 18/11/16
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
130	QC 8	4 pcs	11/19/18	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 16
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
140	Handfinish - 1-1 Chemical-B4B	4 pcs	11/19/18	0.00 0.11	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					D.R 18/11/19
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 -

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				B4B	
150 Powdercoat - 1 White GI(A)- B4B	4 pcs	11/19/18	0.00 0.15	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	BR 18-11-19.
				Powdercoat - 4 - B4B	
160 QC 3	4 pcs	11/19/18	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 16	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
170 Packaging 3-1 - Stock - B4B	4 pcs	11/19/18	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
180 QC 21 - SA	4 pcs	11/19/18	0.00 0.00	QC 21 - SA - 16	
				QC 21 - SA - 21	

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Part Op 100 - (HAAS CNC Vertical Machine), Program part number and batch number MACHINE AS PER DWG AND FOLIO
Descriptions: FB071 FOLIO REV: AA DWG REV: 5

110 - (Manufacture as per dwg), Machine Keyway and inspect per attached dimension sheet

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

M138951-150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 10:30 OVEN TEMPERATURE: 300
FINISH TIME: 11:00

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	100-HAAS 4 Axis	5038654

0-12
88
0-12

0-12
88
0-12

0-12
88
0-12

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-003	4	63	0
Part Specifications				
Specifications could not be found.				

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Container No: S128444



Part: D2661-2

Job No: 186286

Serial No/Batch: S128444

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K64 1K7

CANADA

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Email: sales@dartaero.com

www.dartaerospace.com

Date: 11/16/18

DART AEROSPACE LTD				Work Order: 186 286	
Description: 206 Saddle, Outboard, Right side				Part Number: D2661-2	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	
B	0.256	0.263		.257	.257	.257	.257	
C	0.315	0.322		.316	.316	.316	.316	
D	2.495	2.505		2.500	2.500	2.500	2.500	
E	1.674	1.684		1.679	1.679	1.679	1.679	
F	1.357	1.367		1.362	1.362	1.362	1.362	
G	0.100	0.140		.120	.122	.121	.121	
H	0.210	0.230		.225	.227	.225	.225	
I	0.615	0.685		.680	.680	.682	.683	
J	2.470	2.510		2.494	2.495	2.495	2.495	
K	1.313	1.343		1.325	1.325	1.324	1.325	
L	0.178	0.198		.188	.188	.188	.188	
M	0.470	0.530		.500	.500	.500	.500	
N	1.125	1.145		1.135	1.135	1.133	1.135	
O	0.100	0.180		.135	.132	.133	.135	
P	0.100	0.140		.133	.132	.131	.133	
Q	0.240	0.260		.252	.250	.250	.251	
R	0.677	0.697		.687	.688	.687	.691	
S	0.100	0.140		.127	.129	.128	.127	
T	1.565	1.585		1.575	1.575	1.575	1.575	
U	0.540	0.560		.548	.548	.548	.548	
V	0.912	0.932		.920	.919	.919	.919	
W	0.787	0.807		.796	.796	.795	.795	
X	5.990	6.010		5.995	5.995	5.996	5.996	
Y	4.995	5.005		5.000	5.000	5.000	5.000	
Z	0.490	0.510		.499	.498	.500	.500	
AA	0.312	0.319		.313	.313	.313	.313	
AB	0.990	1.010		1.002	1.001	1.001	1.002	
AC	1.245	1.255		1.250	1.250	1.250	1.250	
AD	0.490	0.510		.501	.500	.500	.501	
AE	3.745	3.755		3.750	3.750	3.750	3.750	
AF	0.235	0.240		.239	.239	.239	.239	
AG	0.510	0.515		.510	.510	.510	.510	
AH	0.100	0.120		.110	.110	.110	.110	

DAS Accept/Reject

Measured by: 57 18/11/16	Date: 18/11/16
Audited by: 9-89 [signature]	Date: 18/11/16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ [signature]	[signature]

